

6061-T6 R0.625"

Work Order ID **78590*****78590***

Page 1

January-11-12 2:42:15 PM

Item ID: D2594-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plug, 205 Skidtube
 Start Date: 11/01/2012 Start Qty: 300.00 ***300*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 300.00 ***300*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2594	Rev C								

100 Hardinge CNC LATHE SMALL 0.00
100
 Hardinge Memo 0.00 SG/SL 12/01/26 301 —
 Hardinge CNC Lathe Small 1-Make as per Dwg D2594-1 and Folio FA262.2-Break all sharp edges 0.010 max.

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 SG/SL 12/01/26 301 —
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 SL 12-01-26
 Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									

301 X 0 m-12/01/27

140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:00								
	FINISH TIME: 11:30								

301 X 0 m-12/01/31

150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

301 counted m-12/01/31

Dart Aerospace Ltd

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: FPA	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

301X C/M-1 12/01/13

12/21/12

CMF 12-221

Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 78590

78590

Parent Item: D2594-1

D2594-1

Parent Item Name: Plug, 205 Skidtube

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 300.00

Required Qty: 300.00

Comments:

IPP D02.08.22Make in CobraKJ

IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased		No		110	f	8.0830	0.0521	16.45263			

M6061T6R0 625

6061-T6 Round Bar .625"

Location

Loc Qty

Loc Code

MAT012

8.083

117284

0.184

119346

7.899

119658

6 ✓
12

→ Not in system
SF 12/01/12

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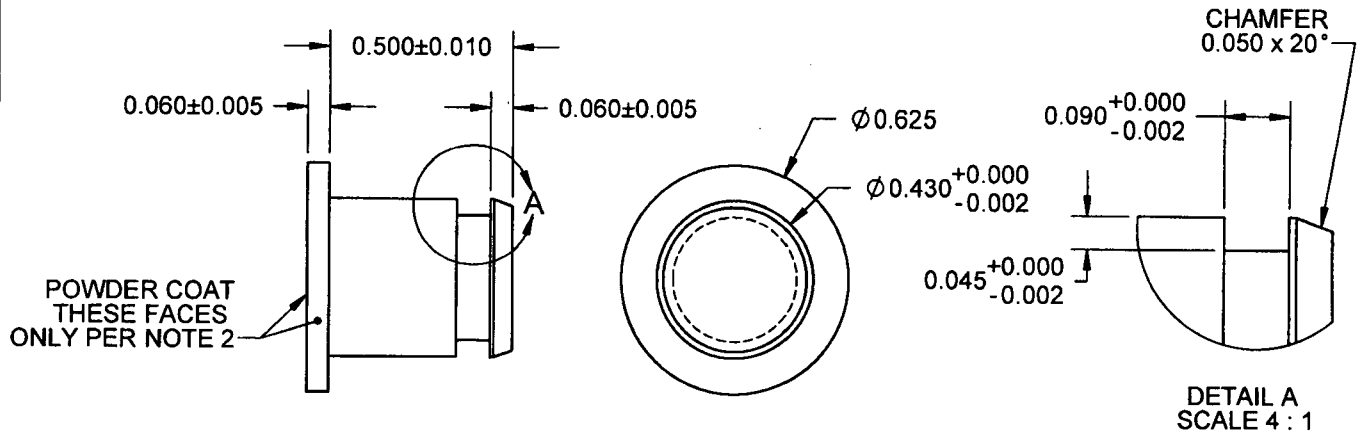
NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28

**D2594-1 PLUG NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

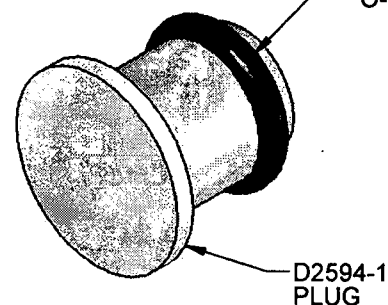
D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

SHOWN
REVISION
ENGINEER
UNCONTROLLED COPY
SUBJECT TO COMMENT
WORK IN PROGRESS
NO. 78590 M.L.J
12/01/11

D2594-3
O-RING**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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